

### Abstract of the Disclosure

A roll forming machine wherein a single operator can quickly replace roll forming stations to change the desired lateral profile and wherein adjustments to the lateral positions  
5 of the roll forming stations can be quickly effected. This is accomplished by mounting the roll forming elements on short tooling rail sections which in turn are mounted on longer mounting rails which are used as platforms whereby all the adjustments are preset so that all setup work is performed prior  
10 to installing the tooling rails. Because the tooling rail sections are shorter, they may be inserted in, and removed from, the machine by a single operator without requiring the partial disassembly, and subsequent reassembly, of the entry and shear assemblies.